

Date: Thursday, 5/4/2006 1:09:56 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	ANGLE BRACKET
<b>Job Number</b> :	27027		
<b>Estimate Number</b> :	12254		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D34813
<b>This Issue</b> :	5/4/2006	<b>Drawing Number</b> :	D3481REV A
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	N/A	<b>Drawing Revision</b> :	A
<b>Previous Run</b> :	N/A	<b>Material</b> :	N/A
<b>Written By</b> :	SEE COMMENT BELOW	<b>Due Date</b> :	5/28/2006
<b>Checked &amp; Approved By</b> :	06.05.05	<b>Qty:</b>	2
<b>Comment</b> :	Est Rev:A New Issue 06-02-07 JLM	<b>Sum:</b>	Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 Cut as per Dwg D3481  
 Dwg Rev: A  
 Prog Rev:

N/A

FF 06.05.16 2

2.0	M304S26GA	304/316 0.018 SHEET
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**Comment:** Qty.: 0.0515 sf(s)/Unit Total: 0.4116 sf(s)  
 304/316 0.018 SHEET  
 (m304s26ga)  
 Batch: M19799

made by Rend

FF 06.05.16 2

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

N/A

SB 06/05/16 2

4.0	QC5	SECOND CHECK
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**Comment:** SECOND CHECK

N/A

SB 06/05/16

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE  
 Form as per Dwg D3481

SB 06/05/16

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 06/05/18

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 5/4/2006 1:09:56 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE BRACKET

Job Number: 27027

Part Number: D34813

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



*206.05.17 (2)*

Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57443*

Job Completion



*Level 21 inspection 10/05/18 (2)*

*U 0605.18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

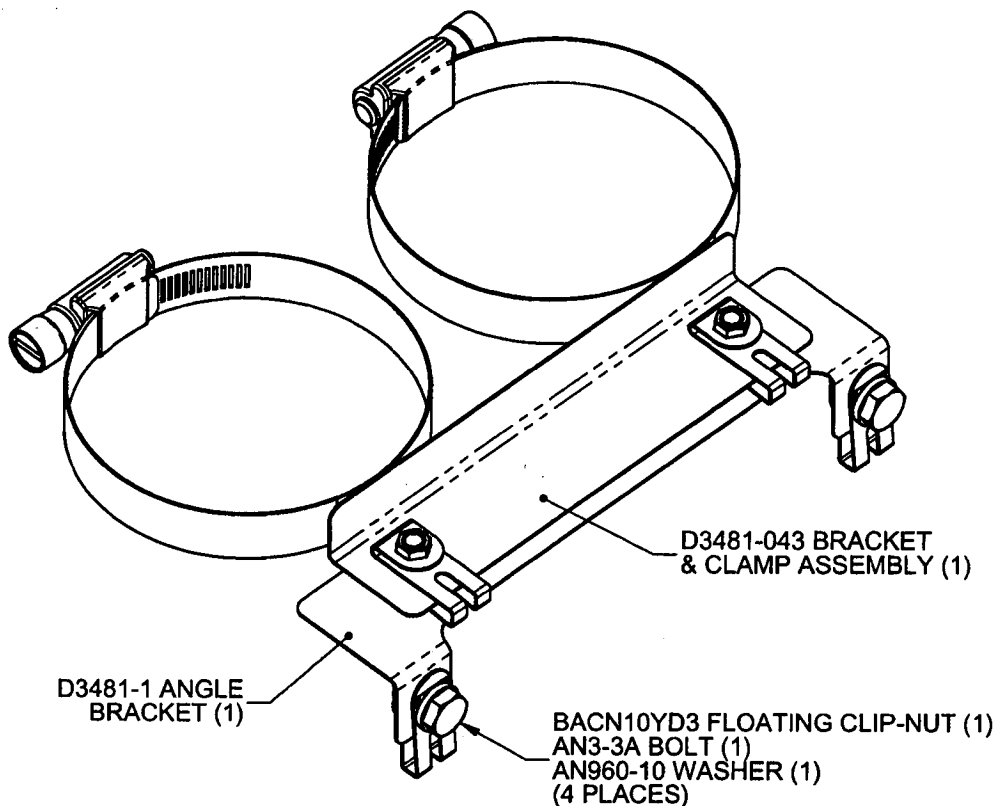
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3481</b>	REV. A SHEET 1 OF 4
DATE <b>06.01.23</b>		TITLE <b>SHUT-OFF VALVE BRACKET</b>	SCALE 2:3
A	06.01.23	NEW ISSUE	

*[Signature]* 06.04.03



### **D3481-041 SHUT-OFF VALVE BRACKET**

1) IDENTIFY WITH DART P/N D3481-041 USING FINE POINT PERMANENT INK MARKER

QTY -041	P/N	DESCRIPTION
X	D3481-041	SHUT-OFF VALVE BRACKET
1	D3481-043	BRACKET & CLAMP ASSEMBLY
1	D3481-1	ANGLE BRACKET
4	AN3-3A	BOLT
4	AN960-10	WASHER
4	BACN10YD3	FLOATING CLIP-NUT

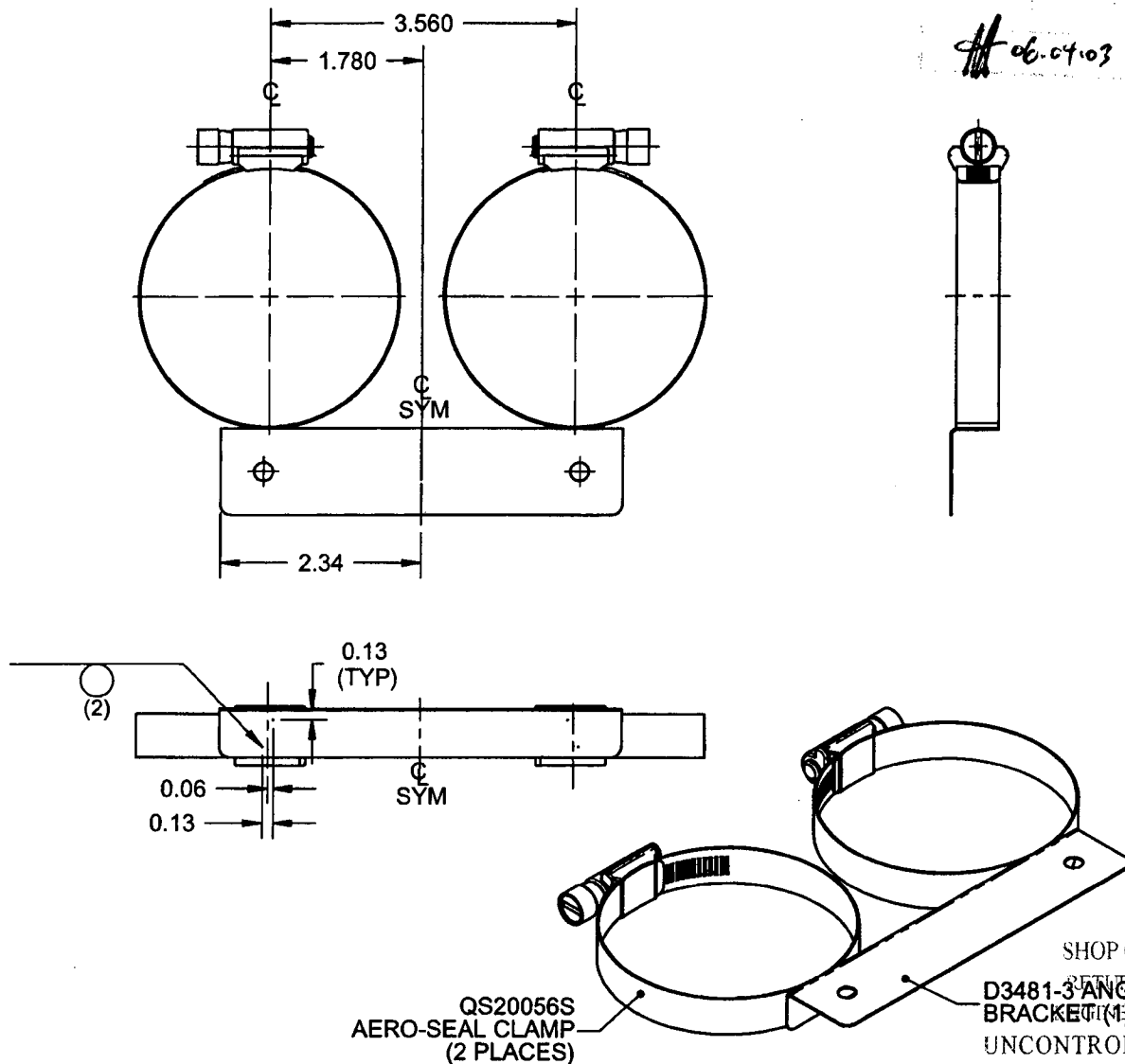
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WORK ORDER  
NO. 27027

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DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2



### D3481-043 BRACKET & CLAMP ASSEMBLY

#### NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

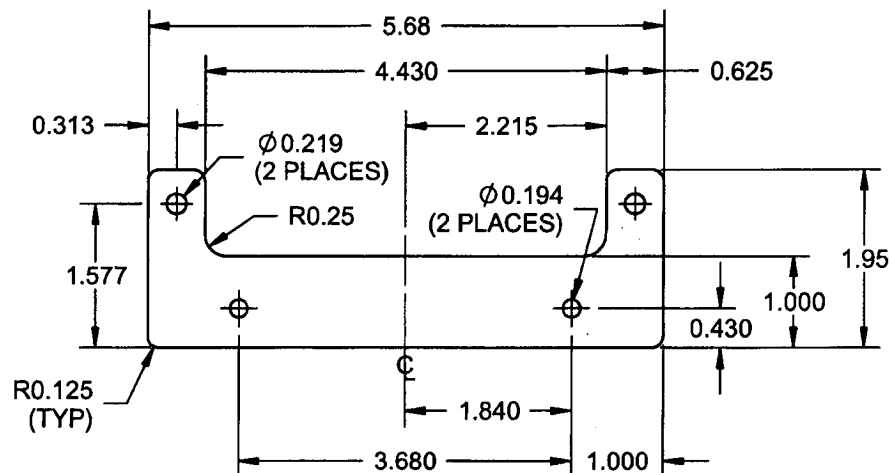
QTY -041	P/N	DESCRIPTION
X	D3481-043	BRACKET & CLAMP ASSEMBLY
1	D3481-3	ANGLE BRACKET
2	QS20056S	AERO-SEAL CLAMP

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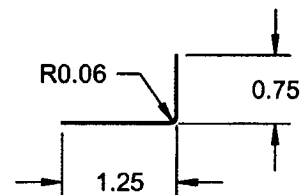
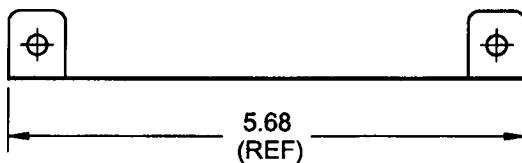
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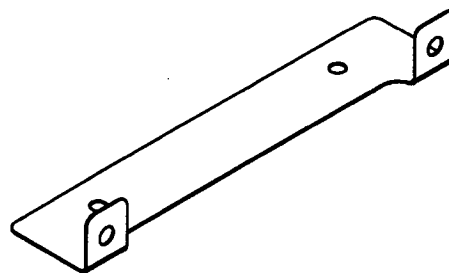
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DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2



**D3481-1F FLAT PATTERN**



**D3481-1 ANGLE BRACKET**



*[Handwritten signature]* 06.04.03

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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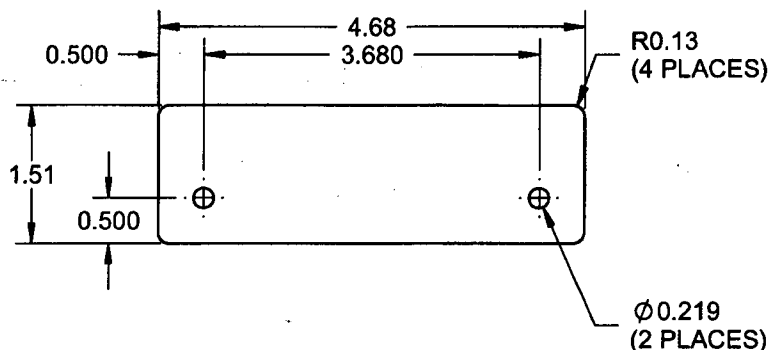
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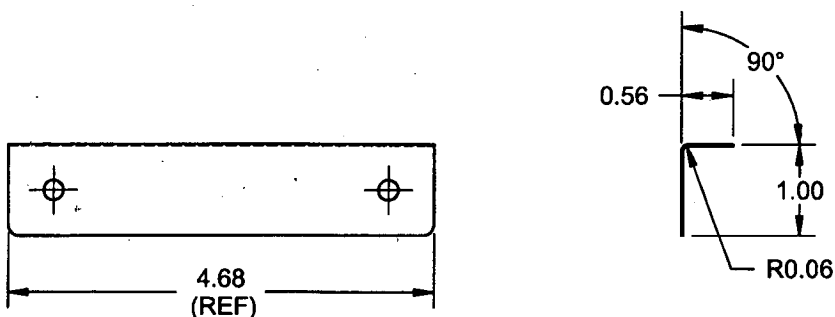


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DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2

*[Signature]* 06.04.03



**D3481-3F FLAT PATTERN**



**D3481-3 ANGLE BRACKET**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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